

Date: Thursday, 29/05/2008 2:34:14 PM
 User: Julie Lecocq

Process Sheet

| | | | |
|------------------------------------|---|---------------------------|---------------------|
| Customer : | CU-DAR001 Dart Helicopters Services | Drawing Name : | HIGH AFT X-TUBE 412 |
| Job Number : | 39579 | | |
| Estimate Number : | 10559 | | |
| P.O. Number : | | Part Number : | D412664203 |
| This Issue : | 29/05/2008 | S.O. No. : | |
| Prsht Rev. : | NC | Drawing Number : | D412-664-243 REV D |
| First Issue : | // | Project Number : | N/A |
| Previous Run : | 39112 | Drawing Revision : | D |
| | Type : | Material : | |
| | CROSSTUBES | Due Date : | 10/06/2008 |
| Written By : | | Qty: | 1 |
| Checked & Approved By : | JW 08.5.29 | Um: | Each |
| Comment : | Est Rev:E 04.02.16 Reformat; Added D3189-1 K/DS Est Rev:F 06-03-29 Remove Coments on Pick List JLM Est Rev:G 06.12.08 per ECN 886 EC Est Rev:H 07-04-30 As per Rev D JLM | | |

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

DC

DOCUMENT CONTROL



66/06/17



Comment: DOCUMENT CONTROL

JW 08.6.17

Photocopy bluefile and create labels as per PPP D412-664-203 CHG 006

2.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

3.0

D412664203TRN

CROSSTUBE TURNING DETAIL



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

CROSSTUBE TURNING DETAIL

batch 039582

EZ 8-5-5

4.0

BENDING

BENDING MACHINE - SKIDTUBES



Comment: BENDING MACHINE

Bend tube as per Dwg D412-664-243 using CNC bender program 412-af and Folio FT010

EZ 8-6-5

5.0

QC15

DIMENSIONAL CHECK OF X-TUBES



Comment: DIMENSIONAL CHECK OF X-TUBES

08.06.05 (1)

B 39579 D 412-664-203

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
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NOTE: Date & initial all entries

Date: Thursday, 29/05/2008 2:34:14 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HIGH AFT X-TUBE 412

Job Number: 39579

Part Number: D412664203

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

CROSSTUBES

CROSSTUBES RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

Scribe B #1 P/N on inner camfer on the cuff.
1-Drill pilot holes in tube as per Dwg D412-664-243 using drill Jig DT8550 & DT8551

2-Ream hole to finish size in tube as per Dwg D412-664-243 using drill Jig DT8550 & DT8551. Check dimensions between holes, both sides on both cuffs, to ensure alignment with saddle holes.

3-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D412-664-243

*EZ/JR
8-6-5*

ANM 8-6-5

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



ANM 8-6-5



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08/06/05 (40)

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/06/05 (40)

10.0

OUTSIDE SERV.10

OUTSIDE SERVICES -skids



Comment: Sub-Contracting OUTSIDE SERVICES

Liquid Penetrant Inspection as per QSI 038Or

Issue P/O: *6525* LPI as per ASTM 1417

Level 2 Attach copy of NDT results to work order

CL 8/06/09 (1)

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Inspect for transit damage

Ensure copy of NDT results attached to work order.

P. J. / S (C)

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HIGH AFT X-TUBE 412

Job Number: 39579

Part Number: D412664203

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

QC5

INSPECT WORK TO CURRENT STEP



ml 08/06/10



①

Comment: Inspect for damage & ensure results are as per Dwg D412-664-203

13.0

SPRAY PAINTING

SPRAY PAINTING



Comment: SPRAY PAINTING

1-Prime inside and outside crosstube as per QSI 005 4.2

2-Paint outside crosstube with White Imron as per QSI 005 4.2

ml 08 06 10

②

14.0

QC14

INSPECT SPRAY PAINT



08 06 11 ①



Comment: Inspect Spray Paint

Wrap in plastic bag to protect from scratches

15.0

D3595063570

RUBBER CUSHION



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Rubber Cushion

Batch: 35126

ml 08 06 12

16.0

D2856600

Abrasion Strip



Comment: Qty.: 1.7640 f(s)/Unit Total: 1.7640 f(s)

Pick:

Qty Part number Description Batch

2 D2856-600(Cut to 10.090") Abrasion Strip 36398

ml 08 06 11

17.0

D28961

Support



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part number Description Batch

1 D2896-1 Support 33471

ml 08 06 12

18.0

D31891

Chafing Shield



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part number Description Batch

2 D3189-1 Chafing Shield 37884

ml 08 06 12

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HIGH AFT X-TUBE 412

Job Number: 39579

Part Number: D412664203

Job Number:



Seq. #:

Machine Or Operation:

Description :

19.0

MS2192028

Clamp(per MIL-DTL-8783C)



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part number Description Batch

4 MS21920-28 Clamp 107502

ml 08 06 12

20.0

MS2192030

clamp(per MIL-DTL-8783C)



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

clamp(per MIL-DTL-8783C)

batch: 106810

ml 08 06 12

21.0

CROSSTUBES

CROSSTUBES RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

Assemble as per Dwg D412-664-203

1- Lightly scuff the bonded area using a 320 grit sand paper and clean the area with 41058 wash 'n' wipe

ml 08 06 12 (1)

2-Install supports with magnobond as per QSI 015 Adhere for for 12 Hrs

A/R 6398 Magnobond

Batch: 107621

Expiry Date: 08/2009

Time: 9:00AM

3-Install clamps as per Dwg D212-664-141. Torque clamps to 80-100 in lb.

ml 08 06 13

(1)

22.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Job 16 @

23.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

24.0

AN640A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

Batch: M167376

JS 08/06/17 (X)

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HIGH AFT X-TUBE 412

Job Number: 39579

Part Number: D412664203

Job Number:



Seq. #:

Machine Or Operation:

Description :

25.0

AN641A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

Batch: M167013

JS 08/06/17 (X1)

26.0

AN960JD616

Washer



Comment: Qty.: 18.0000 Each(s)/Unit Total : 18.0000 Each(s)

Washer

Batch: M107242

JS 08/06/17 (X1)

27.0

MS21042L6

Nut



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Nut

Batch: M105077

JS 08/06/17 (X1)

28.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

JS 08/06/17 (X1)

29.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D412-664-203

*****Ensure tube is not packaged if curing time is less than 12 hrs, see step 27 for application time & date

Time & date of packaging: 08/06/17 1:15 PM

Location:

PPP Rev:

Rev G

JS 08/06/17 (X1)

30.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/06/17

Job Completion



u 08.06.18

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

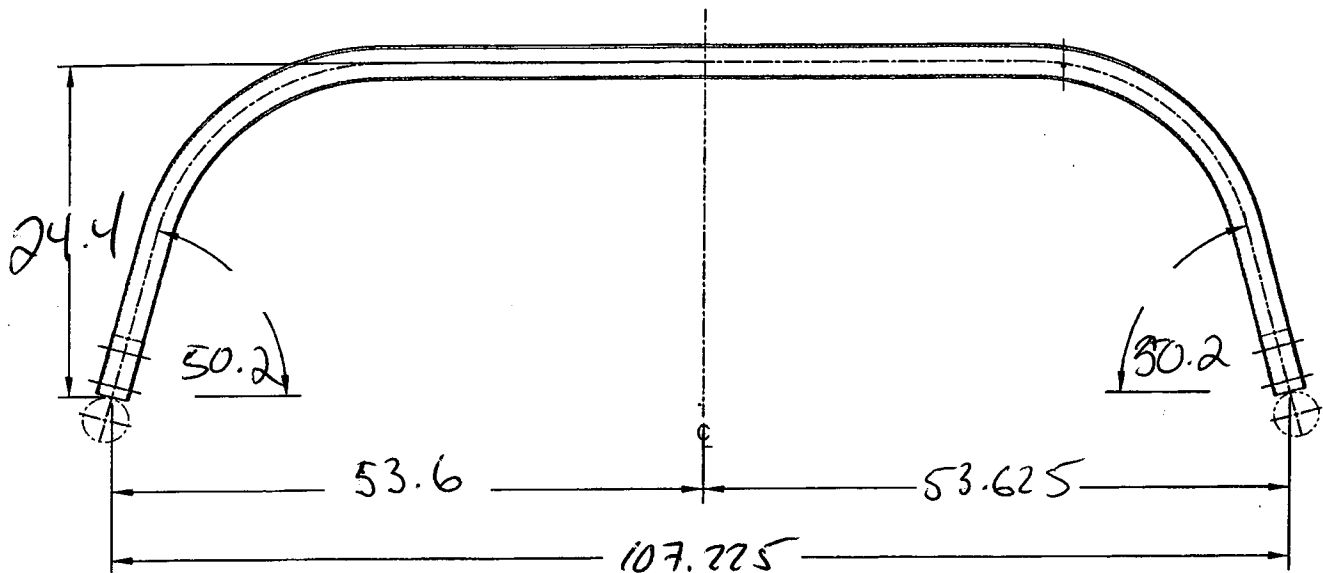
QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

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|---------------------------------------|--|--------------|--------------|
| DART AEROSPACE LTD | | Work Order: | 39579 |
| Description: Crosstube High Aft (412) | | Part Number: | D412-664-203 |
| Inspection Dwg: D412-664-243 Rev: D | | Page 1 of 1 | |

| Required Dimension | Min | Max |
|--------------------|--------|--------|
| Height | 24.24 | 24.50 |
| 1/2 Span | 53.59 | 53.85 |
| Angle | 49 | 52 |
| Total Span | 107.18 | 107.70 |



| Comments |
|----------|
| |
| |
| |
| |

| | |
|-----------------|----------|
| QC15 Inspection | |
| Date | 08-06-05 |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|-----------------------------------|------------|----------|
| A | 07.02.06 | New Issue | KJ/JM | |
| B | 07.05.08 | Dimensions updated per Dwg rev. D | KJ/JLM | |

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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NOTE: Date & initial all entries

DART

| | | | |
|----------------------|--------------------------------|---|------------------------|
| DESIGN PH | DRAWN BY PH | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED GP | APPROVED [Signature] | DRAWING NO. D412-664-243 | REV. D SHEET 1 OF 3 |
| DATE 07.03.09 | | TITLE CROSSTUBE ASSEMBLY (412 HI AFT) | SCALE NTS |
| A | 01.10.17 | NEW ISSUE | |
| B | 05.02.04 | ADD HOLES FOR COMPATABILITY WITH BHT/AA SKIDTUBES | |
| C | 06.10.27 | REMOVE D2856-600-1087, ADD D2732-058 & MAGNOBOND 6398 MS21920-32 WAS MS21920-30 | |
| D | 07.03.09 | REMOVE D2732-058, CHANGE TO D3595-063-570 | |

RELEASE07.04.24 **[Signature]**

| Qty | Part Number | Description |
|-----|----------------|---|
| X | D412-664-243 | CROSSTUBE ASSEMBLY (412 HIGH AFT) |
| 1 | D6009-129 | CROSSTUBE |
| 2 | D3595-063-570 | RUBBER CUSHION |
| 1 | D2896-1 | SUPPORT |
| 2 | D2856-600-1009 | ABRASION STRIP |
| 4 | MS21920-28 | CLAMP |
| 2 | MS21920-30 | CLAMP (OR MS21920-32) |
| 2 | D3189-1 | CHAFING SHIELD |
| A/R | MAGNOBOND 6398 | ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299-947-100, TYPE II, CLASS 2 ADHESIVE) |

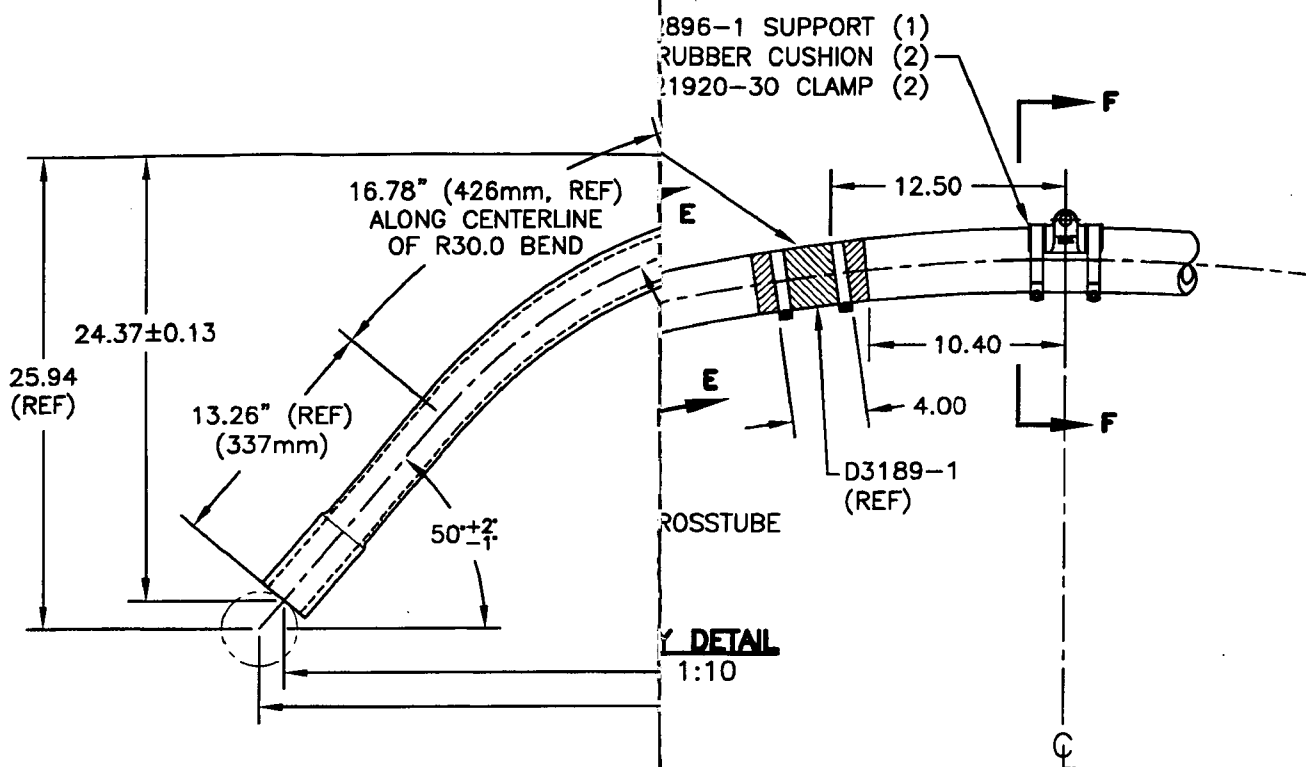
GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 2) MATERIAL: MANUFACTURED FROM D6009-129
FINISHED LENGTH = 124.09±0.020
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART 005 4.2
- 4) PART IS SYMMETRIC ABOUT CENTERLINE.
- 5) RUN-OFF PART. BLEND OUT EDGE LONGITUDINALLY, TRANSITION SHOULD BE SMOOTH.
- 6) BEND PROGRESSIVELY WITH A MINIMUM OF 8 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- 7) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 8) SCRIBE DART PART NUMBER AND BATCH NUMBER IN THIS AREA WITH VIBRATING STYLUS.
- 9) INSTALL D2856-600-1009 ABRASION STRIP WITH A 0.13 (REF) GAP ON BOTTOM SIDE OF CROSSTUBE PER QSI 035.
- 10) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 11) APPLY A 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 TO THE SURFACE OF D2896-1 THAT WILL BE IN CONTACT WITH THE CROSSTUBE PER QSI 015. LET CURE FOR 12 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.
- 12) INSTALL MS21920-30 CLAMPS (OR -32) WITH D3595-063-570 RUBBER CUSHIONS TO SECURE D2896-1 SUPPORT ON TOP SIDE OF THE CROSSTUBE. ENSURE CLAMPS ARE OPPOSITE CROSSTUBE SUPPORT.
- 13) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.

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RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 391579

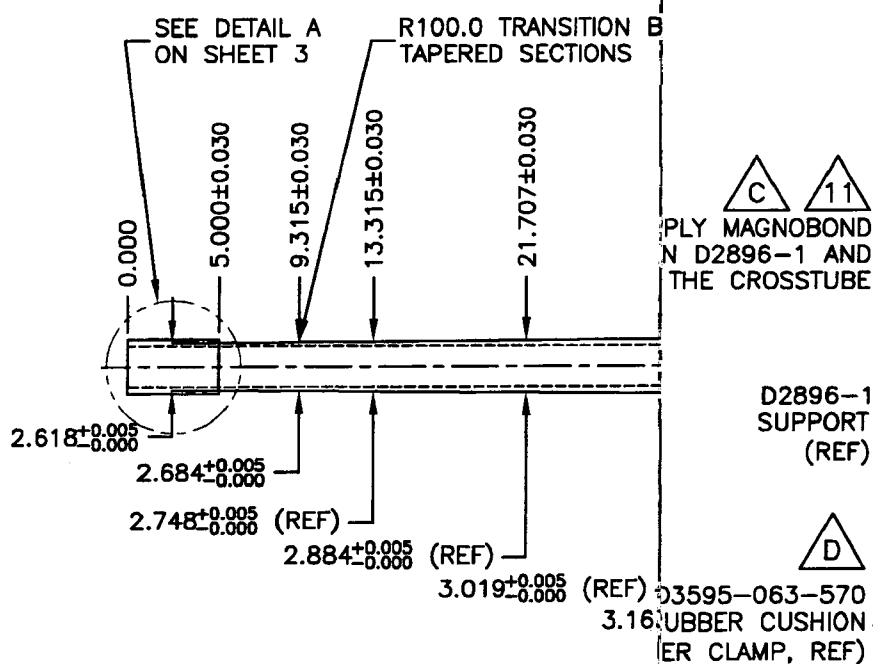
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RELEASE

07.04.24



SECTION F-F
 SCALE 2:5

D2896-1
 SUPPORT
 (REF)

D

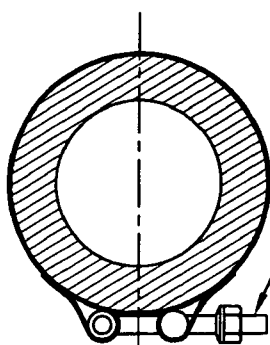
MS21920-30
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12

13

MS21920-30
 CLAMP (REF)

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 WITHOUT NOTICE
 WORK ORDER
 NO. 39579



SECTION E-E
 SCALE 2:5

MS21920-28 CLAMP (REF)

OWN BY

PH

DART

DART AEROSPACE LTD.
 HAWKESBURY, ONTARIO, CANADA

APPROVED

DRAWING NO.

D412-664-243

REV. D

SHEET 2 OF 3

TITLE

SCALE

CROSSTUBE ASSEMBLY (412 HI AFT)

1:10



LIQUID PENETRANT TEST REPORT

P- 09176

PAGE 1 OF 1

CLIENT DART AEROSPACE DATE JUNE 09 2008
ATTENTION LINDA LACELLE ACUREN JOB NO. 188-08-1354
ADDRESS 1270 ABERDEEN ST. PO/VO No. 6525
HAWKESBURY, ON WORK LOCATION HAWKESBURY
ACCEPTANCE STD. ASTM1417/Q51-038 REV./DATE 2005

PROJECT 3 x 203 2x 101
ITEM(S) EXAMINED 203-(39579) 39580, 38965
101- 39274, 39273

JOB DESCRIPTION PROCEDURE No. LT 002 REV./DATE TECHNIQUE No. LT TECH 2 REV./DATE
PART NO. 3pcs D412664203 MATERIAL ALODINED ALUM. THICKNESS
SCOPE 2pcs D212664101
SCOPE WET FLOURESCENT LIQUID PENETRANT INSPECTION 100% EXTERNAL SURFACE

TEST DETAILS
METHOD ☒ FLUORESCENT ☐ VISIBLE ☒ WATER WASH ☐ SOLVENT REMOVABLE ☐ POST EMULSIFIED
FAMILY BRAND BLACK LIGHT S/N 8171 ☐ OUTPUT > 1000 μ W/cm² ☐ AMBIENT < 2 fc
PENETRANT MINIMUM DWELL TIME 40-45 MIN. LIGHTING EQUIP. ☐ FLASHLIGHT ☐ TROUBLELIGHT ☐ OUTPUT > 100 fc @ SURFACE
PENETRANT REMOVER H2O MINIMUM DRY TIME >10 MIN. OTHER CAL FEB 12 2008
DEVELOPER SKD 20 MINIMUM DWELL TIME 10 MIN. LIGHT METER S/N CAL DUE DATE
DEVELOPER TYPE ☒ NON AQUEOUS ☐ AQUEOUS ☐ DRY

TEST SURFACE
SURFACE CONDITION ☐ AS GROUND ☐ AS WELDED ☐ MACHINED ☐ SHOT BLASTED ☒ CLEAN BARE METAL
SURFACE TEMPERATURE ☐ < -4°C/ 20°F ☐ -4°C/ 20°F TO 10°C/50°F ☐ 10°C/50°F TO 52°C/125°F ☐ > 52°C/125°F

RESULTS- ☐ METRIC ☒ IMPERIAL

| ITEM | COMMENTS | ACCEPT | REJECT |
|----------|--------------------------------|--------|--------|
| | FLUORESCENT LIQUID PENE. INSP. | | |
| | CARRIED OUT ON 100% OF | | |
| | EXTERNAL SURFACE ONLY | | |
| 3pcs 203 | JOB# (39579) 39580, 38965 | | |
| 2pcs 101 | JOB# 39273, 39274 | | |

RESULTS NO INDICATIONS OF DEFECTS

ITEMS ACCEPTABLE TO STANDARD

Scope of Services

The agreement of Acuren Group Inc. to perform services extends only to those services provided for in writing. Under no circumstances shall such services extend beyond the performance of the requested services. It is expressly understood that all descriptions, comments and expressions of opinion reflect the opinions or observations of Acuren Group Inc. based on information and assumptions supplied by the owner/operator and are not intended nor can they be construed as representations or warranties. Acuren Group Inc. is not assuming any responsibilities of the owner/operator and the owner/operator retains complete responsibility for the engineering, manufacture, repair and use decisions as a result of the data or other information provided by Acuren Group Inc. In no event shall Acuren Group Inc.'s liability in respect of the services referred to herein exceed the amount paid for such services.

Standard of Care

In performing the services provided, Acuren Group Inc. uses the degree, care and skill ordinarily exercised under similar circumstances by others performing such services in the same or similar locality. No other warranty, expressed or implied, is made or intended by Acuren Group Inc.

SIGNATURES

CLIENT REPRESENTATIVE [Signature] DTR #
TECHNICIAN (SIGNATURE): [Signature] REPORT
NAME (PRINT): J BILMER REVIEWED BY:
CGSB LEVEL 2 SNT LEVEL 9901 CGSB LEVEL 2 SNT LEVEL
CGSB REG. No 9901 CGSB REG. No